

Aero Design Ltd.**Work Order Control Sheet****Work Order#: 2017-105 Date Opened: 22 June 2017 Title: Fabrication****Aircraft OEM: Airbus Helicopters Aircraft Model: AS350/AS355 Product Type: Bike racks Product Model: Straps Quantity: 144****Work Order Contents**

	Initial or N/A
Work Order/Build Sheets (Procedures Provided)	JC
Additional Work Sheets (Standard Practice)	N/A
Drawings (See List Below)	JC
Parts Distribution Sheet	JC
Sub Component Tags	N/A
Completed Certification (Original)	JC
Time Sheet (R&D)	N/A
Notes	N/A

Build Sheet Contents

Tasks Initialled	JC
Dual Inspections Initialled	JC

Drawing List

Drawing #	Rev #	Description	Initial or N/A
100225	0	Strap	JC

Traveller**Component Completion**

	As Instructed
Quantity Complete on This Work Order	144
Quantity Incomplete on This Work Order	N/A
Further Processing Required Before Release	N/A
Release to Stock as Components	N/A

Certification

	Initial or N/A
Form One Completed	N/A
Serviceable (Green) Tag Completed	JC
In Process (Yellow) Tag Completed	N/A
Unserviceable (Red) Tag Completed	N/A
Parts Tracking Tags (White) Completed	N/A
Parts Placed in Stores for Distribution	N/A

Additional Documentation

	Initial or N/A
Documentation of a minor change	N/A
Non-Conformance Report Required	N/A
Service Difficulty Report Required	N/A

Billing

Local (Aero Design)	JC
Research and Development	N/A
Third Party	N/A

Work performed by:

Print: J. Clarke

ICC / Dual Inspection performed by:

Print: J. Rekve

Work Order closed by:

Print: J. Clarke

Approved Manufacturing Facility 73-04

Sign:

Sign:

Sign:

Form 2014-03

SCA: AD02

SCA: AD01

SCA: AD02

Date: 05-Sep-17

Date: 05-Sep-17

Date: 22-Sep-17

Rev. Original 23 Sep 2014



Aero Design Ltd.

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Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

In Process

Remarks

6/bar x 24 bars = 144 parts

6 bars completed for powder coat 24 June 2017 J.

Remainder complete, GRN tag issued 22 Sept 2017 J.



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AMF 73-04

Nomenclature: STRAP No. of pieces: 144

Manufacturer: AERO DESIGN LTD.

Part No.: 100225-01 Serial/Batch No.: PO 17053

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2017-105

Remaining Tasks to be Performed: MACHINING, DEBURRING, INSPECTION

POWDER COATING, FINAL INSPECTION

Signature: Jff CLK.

Date: 22 JUNE 2017 Lic. No. / SCA A002

In Process

BICYCLE RACK STRAP – 100225-01

Work Order: ~~2017-107 JC~~ 2017-105

Quantity: 144

Complete
(initial or SCA #)

Date Open: 22 JUNE 2017

PO# 17053

24 bars x 6

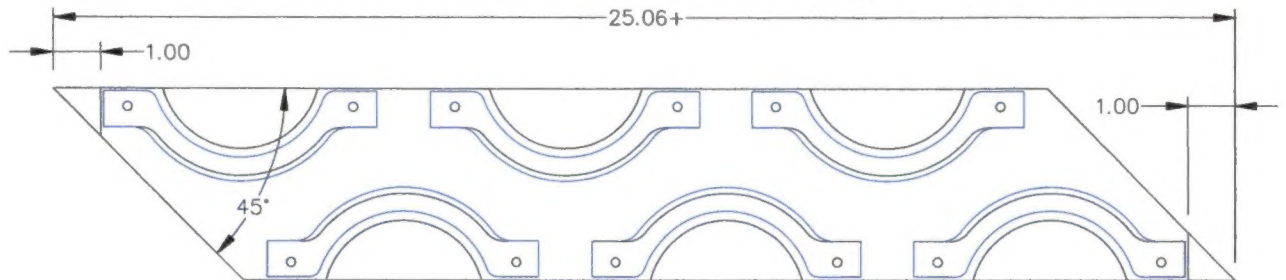
General

These instructions apply to fabrication of AS350/AS355 bicycle rack frame straps. Refer to the following drawings, at the current revision, for dimensions and details:

100225, Revision 0 – Strap Fabrication

1. Cut stock:

- a. Cut 1" x 4" 6061-T6 aluminum bar to length shown with 45 degree cuts off ends:



- b. Record PO.

2. Machining:

- a. Insert stock on CNC using 1/8" deep vise jaws.
b. Set 0 on top left far corner.
c. Run program to machine holes.
d. Deburr holes edges.
e. Tag in process parts.

3. Machining:

- a. Locate jig in CNC using 1/8" deep vise jaws. Fasten stock to jig using AN3 bolts.
b. Set 0 on top left far corner.
c. Run program to face to machine straps.
d. Flip parts and run program to finish profile on far side.
e. Update tag for in process parts.

4. Machining:

- a. Install jig vise jaw to hold part open side up.
b. Set 0 on top left far corner.
c. Run program to machine slots.
d. Update tag for in process parts.

5. Deburring:

- a. Deburr all edges.
b. Update tag for in process parts.



AD
73-04
02

AD
73-04
02

6. Inspection:

To be completed by a different person than the previous steps.

- a. Inspect 100230-02 beam adapters for conformity to drawings.
- b. Update tag for in process parts.

7. Powder Coating:

- a. Parts are powder coated using commercial process.
- b. Record PO.
- c. Update tag for in process parts.

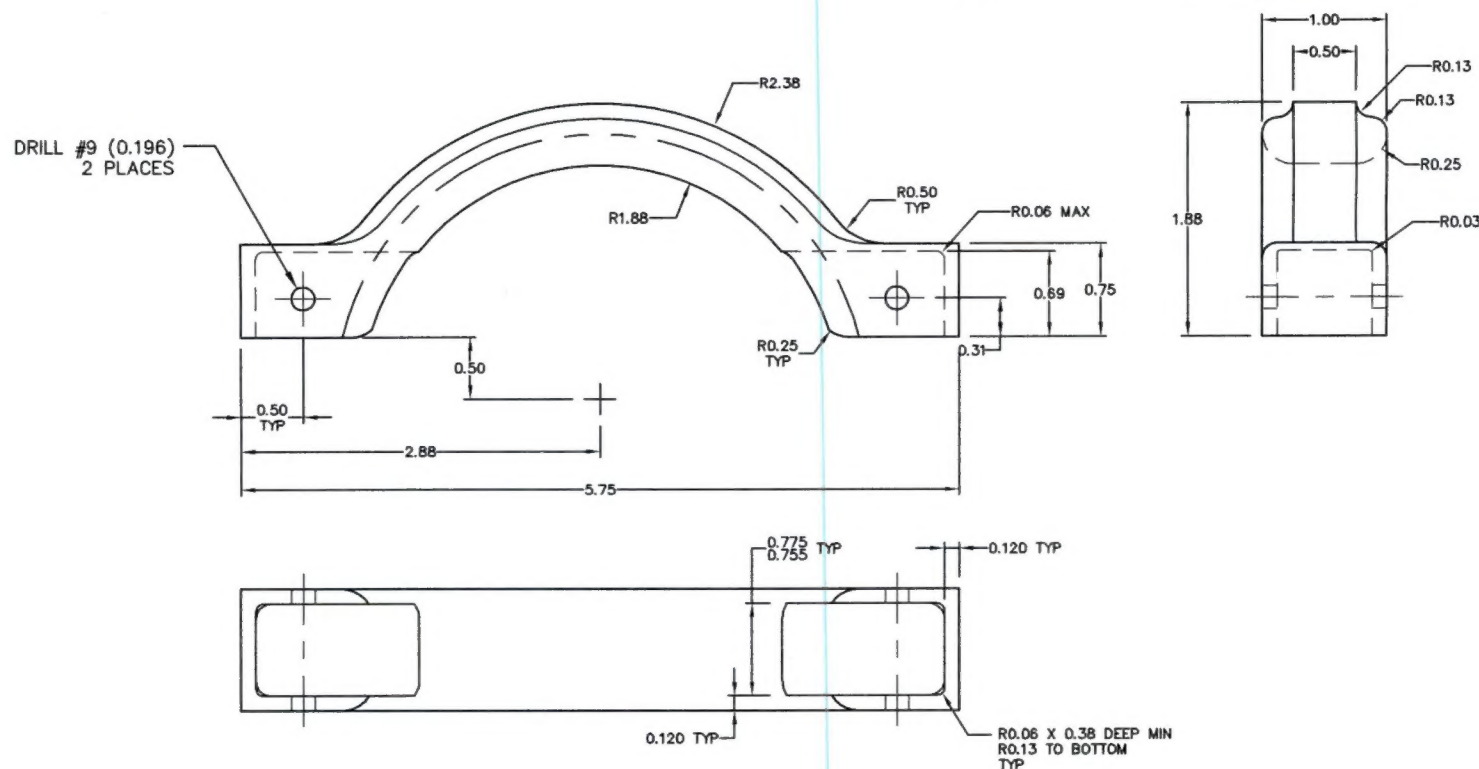
8. Final Inspection:

- a. Inspect 100225-01 Strap to ensure acceptable powder coating.
- b. Issue green tag for completed parts.

2017-105

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		



① STRAP

NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.

2. FINISH - ALUMINUM PARTS:

THOROUGHLY DEGREASE, ALODINE, EPOXY PRIME AND POLYURETHANE PAINT.


ALTERNATE: ANODIZE IN ACCORDANCE WITH MIL-A-8625F, TYPE II.

ALTERNATE, POWDER COATING:

- THOROUGHLY DEGREASE USING TOP CHEMICALS TOP COAT 8888 DEGREASER / IRON PHOSPHATE @ 3% BY VOLUME.

- POWDER COAT USING SHERWIN WILLIAMS POLYESTER SUPER DUTY POWDER OR EQUIVALENT POWDER COAT MATERIAL AND PROCESS THAT DOES NOT EXCEED TEMPERATURE/TIME LIMITS NOTED BELOW.

- CURE POWDER COATING AT 392°F (±10°F) FOR 20 MINUTES (±3 MIN).

100225-01	01	STRAP	6061-T6 ALUMINUM	QQ-A-200/8	2 X 1 BAR
PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY LIST OF MATERIALS					
APPROVALS		DATE	 AERO DESIGN LTD. 9888A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 604.485.2376 www.aerodesign.ca		
DRAWN: JEFF CLARKE		13 JUNE 2016			
CHECKED: JASON REKVE		13 JUNE 2016			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:			AIRBUS HELICOPTERS AS350/AS355/EC130 BICYCLE RACK INSTALLATION STRAP FABRICATION		
DECIMALS		ANGLES			
X.XXX ±0.010		±1/2°	SCALE 1 : 1	DWG. SIZE A3	DWG. NO. 100225
X.XX ±0.03					
X.X ±0.1			SHEET 1 OF 1	REV. 0	

[illegible]